



Dart Hawkesbury  
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**D4634-145**  
**Job Sheet 167078-E**



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |
| 90    | Start up Operation | 1 Ea  |            | 11/9/17  | 0.00      | 0.00    | Start up container    |           |
| 100   | HandThermo         | 1 pcs |            | 11/9/17  | 0.00      | 1.65    | HandFinish4           |           |
| 110   | Small Fab          | 1 pcs |            | 11/10/17 | 0.00      | 1.47    | Small Fab             |           |
| 120   | QC                 | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | QC5                   |           |
| 130   | Packaging          | 1 pcs |            | 11/10/17 | 0.00      | 0.00    | Packaging3            |           |
| 140   | QC21-SA            | 1 Ea  |            | 11/10/17 | 0.00      | 0.00    | QC21                  |           |

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: \_\_\_\_\_

140 - QC21- Final Inspection - Work Order Release

### Job Allocations

| Operation             | Component Part                                | Required         | Inventory | Allocated | Std Qty |
|-----------------------|-----------------------------------------------|------------------|-----------|-----------|---------|
| 90-Start up Operation | D4634-5 <u>502271</u>                         | 1 <u>5022730</u> | 3         | 0         | 0       |
|                       | D4636-5 <u>5022280</u>                        | 1                | 43        | 0         | 0       |
|                       | D4647-1 <u>5022288</u>                        | 1                | 4         | 0         | 0       |
|                       | <u>5022281x3</u> D4664-5 <u>5022281</u>       | 6 <u>5022281</u> | 39        | 0         | 0       |
|                       | D4712-1 <u>5022284</u>                        | 1                | 4         | 0         | 0       |
|                       | D4732-17 <u>5022282</u>                       | 1                | 0         | 0         | 0       |
|                       | D4732-23 <u>5022281</u>                       | 1                | 1         | 0         | 0       |
|                       | D4732-27 <u>5022280</u>                       | 1                | 1         | 0         | 0       |
|                       | D5021-5 <u>5022273</u>                        | 1                | 1         | 0         | 0       |
|                       | <u>5022270x3</u> MPNY-750S-9-C <u>5022258</u> | 9                | 570       | 0         | 0       |
|                       | MS20426AD3-4 <u>5022257</u>                   | 4                | 5,055     | 0         | 0       |
|                       | MS20426AD4-6 <u>5022256</u>                   | 2                | 2,797     | 0         | 0       |
|                       | MS21059L08 <u>5022255</u>                     | 2                | 62        | 0         | 0       |
|                       |                                               |                  |           |           |         |

### Part Specifications

Specifications could not be found.

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/><br/>             Machining <input type="checkbox"/><br/>             Thermoforming <input type="checkbox"/><br/>             Large Fab <input type="checkbox"/> </div> <div>             Cross tube <input type="checkbox"/><br/>             Small Fab <input type="checkbox"/><br/>             Finishing <input type="checkbox"/><br/>             Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/><br/>             Prod. Eng. Coord. <input type="checkbox"/><br/>             Rec/Store/Packaging <input type="checkbox"/><br/>             Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/><br/>             Quality <input type="checkbox"/><br/>             Other <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                               |  |                       |  |                                                 |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Step #: _____                                                                                                                                                                      | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  | MRB (QSI042) Approval |  |                                                 |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                    | <div style="position: relative; width: 100%; height: 100%;"> <div style="position: absolute; top: 10px; right: 10px; font-size: 0.8em;"> <b>Dart Aerospace Ltd.</b><br/>             1270 Aberdeen Street<br/>             Hawkesbury, ON K6A 1K7<br/>             CANADA<br/>             TEL.: 1 613 632-5200<br/>             Email: sales@dartaero.com<br/>             www.dartaerospace.com           </div> <div style="position: absolute; top: 40%; left: 10%; font-size: 1.5em; font-weight: bold;">             S022947<br/> <br/>             Aft, Center Ceiling Replacement Panel Assembly           </div> <div style="position: absolute; top: 60%; left: 30%; font-size: 1.5em; font-weight: bold;">             D4634-145<br/>             Start up Operation<br/> <div style="border: 2px solid black; padding: 5px; transform: rotate(-5deg); display: inline-block;">               Mfg Date: 12/15/17<br/>               Job No: 167078-E             </div> </div> <div style="position: absolute; bottom: 10%; left: 10%; font-size: 1.2em; font-weight: bold;">             PART NO:<br/>             Revision:<br/>             Operation:<br/>             Change No:           </div> </div> |  |                       |  |                                                 |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                       |  | Completed By                                    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                       |  | Lead hand / Supervisor<br>Approval Verification |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                       |  | QC / QA Coordinator<br>Approval                 |  |
| <b>Root Cause</b><br><div style="display: flex;"> <div style="width: 50%;">             Environment <input type="checkbox"/><br/>             Design <input type="checkbox"/><br/>             Doc/Data <input type="checkbox"/><br/>             Equip/Tooling <input type="checkbox"/><br/>             Handling/Pre <input type="checkbox"/><br/>             Material <input type="checkbox"/><br/>             Internal Transport <input type="checkbox"/><br/>             Tribal Knowledge <input type="checkbox"/><br/>             LOA <input type="checkbox"/><br/>             Substation <input type="checkbox"/><br/>             Past Expiry Date <input type="checkbox"/><br/>             Misidentified <input type="checkbox"/> </div> <div style="width: 50%;">             No Re-verificat <input type="checkbox"/><br/>             Operator <input type="checkbox"/><br/>             Offset/Setup <input type="checkbox"/><br/>             Supplier <input type="checkbox"/><br/>             Training <input type="checkbox"/><br/>             Use for Testing <input type="checkbox"/><br/>             Poor Information <input type="checkbox"/><br/>             Rushing <input type="checkbox"/><br/>             Product Improvement <input type="checkbox"/><br/>             Process Improvement <input type="checkbox"/><br/>             Manufacturing Process <input type="checkbox"/><br/>             Past Due <input type="checkbox"/> </div> </div> |                                                                                                                                                                                    | <div style="display: flex; justify-content: space-between;"> <div>             Instructions Incomplete/Unclear <input type="checkbox"/><br/>             Drill Holes <input type="checkbox"/> </div> <div>             Off-set <input type="checkbox"/><br/>             Mislabeled <input type="checkbox"/><br/>             Fit/Function <input type="checkbox"/><br/>             Misaligned/off center <input type="checkbox"/> </div> <div>             Positioned Wrong <input type="checkbox"/><br/>             Outside Dimensions <input type="checkbox"/><br/>             Over/Under tolerance <input type="checkbox"/><br/>             Part Incorrect <input type="checkbox"/><br/>             Part Lost/Missing <input type="checkbox"/><br/>             Part Moved <input type="checkbox"/><br/>             Drawing <input type="checkbox"/><br/>             Finish <input type="checkbox"/><br/>             Misread <input type="checkbox"/><br/>             Turning Sequence <input type="checkbox"/> </div> </div>                                                                                                                                                                               |  |                       |  |                                                 |  |
| OTHER : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  |                       |  |                                                 |  |